

Date: Thursday, 4/12/2007 9:33:19 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	REDUCER TEE ASSY		
Job Number	31779					
Estimate Number	12762					
P.O. Number	N/A		Part Number	41232 200 004 001		
This Issue	4/12/2007	S.O. No.	N/A	Drawing Number	41232-200-004 REV IR	
Prsht Rev.	NC			Project Number	N/A	
First Issue	N/A	Type	MACHINED PARTS	Drawing Revision	IR	
Previous Run	31018			Material	N/A	
Written By			Due Date	5/10/2007	Qty:	20
Checked & Approved By	<u>JL</u>		Um:	Each		
Comment	Est Rev:A New Issue 07-03-01 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	AN8154J	union			
	Comment: Qty.: 1.0000 Each(s)/Unit	Total : 20.0000 Each(s)			
	union				
	Batch: M1041253		EC	07-04-30	20
2.0	AS1035J080812	TEE			
	Comment: Qty.: 1.0000 Each(s)/Unit	Total : 20.0000 Each(s)			
	TEE				
	Batch: M104197		MS	07/04/30	20
3.0	LATHE CONV.	CONVENTIONAL LATHE			
	Comment: CONVENTIONAL LATHE				
	1-Turn AN815-4J as per Dwg 41232-200-004				
	2-Deburr as Required.		MS	07/04/30	20
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE			
	Comment: CONVENTIONAL MILLING MACHINE	H			
	OK				
	1-Drill as per Dwg 41232-200-004				
	2-Deburr		MS	07/04/30	19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 5/6/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
5/04/07	4.0	1 part scrap, setup error <i>Q510412</i>	<i>Q510412</i>	Scrap part	<i>P</i> 01-05-07	<i>AA</i> 01/05/07	<i>Q510412</i>	<i>AA</i> 01/05/07

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: REDUCER TEE ASSY

Job Number: 31779

Part Number: 41232 200 004 001

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS

07/04/30

19

6.0 QC8

SECOND CHECK



Comment: SECOND CHECK

3G

07.001.30

19

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg 41232-200-004

A/R SS Rod

Batch: M102756

10/05/07 19

8.0 QC5/9

WELD INSPECTION



Comment: 1-WELD INSPECTION

PD 07-05-07 19

2-Pressure test as per Dwg 41232-200-004

PD 07-05-08 19

48-Passivate Finish.

07-05-08

Soudotec Passivating Solution 623745 M102991 19

3- Pickling Paste

Soudotec Pickling Paste 624809 B/M M102991

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/05/08 7/5/08 SP

19

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/10

19

Job Completion



W/D 05-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

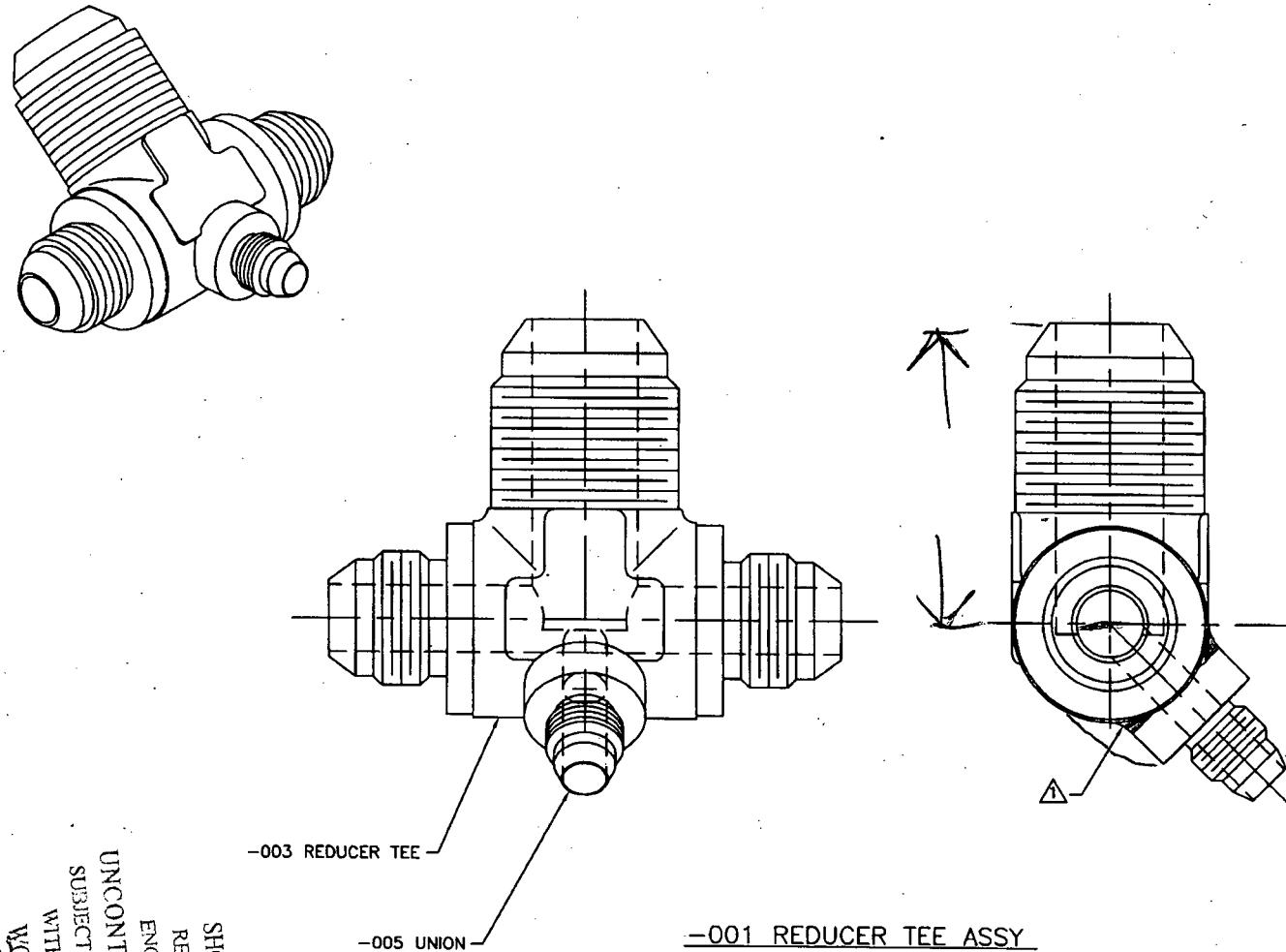
DART AEROSPACE LTD	Work Order:	31779
Description: Reducer Tee Assembly	Part Number:	41232-200-004-001
Inspection Dwg: 41232-200-004      Rev: IR		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>MB</u>	Audited by:	<u>BL</u>	Prototype Approval:	N/A
Date:	07/04/30	Date:	07-04-30	Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	07.04.02	New Issue	KJ/JLM	



-003 REDUCER TEE

-005 UNION

-001 REDUCER TEE ASSY

NO. 31779  
WORK ORDER  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

⚠ PRESSURE TEST TO 3,000 PSI.

⚠ QQ-P-35 PASSIVATE FINISH AFTER WELD.

⚠ WELD IN ACCORDANCE WITH MIL-STD-2219 CLASS C.

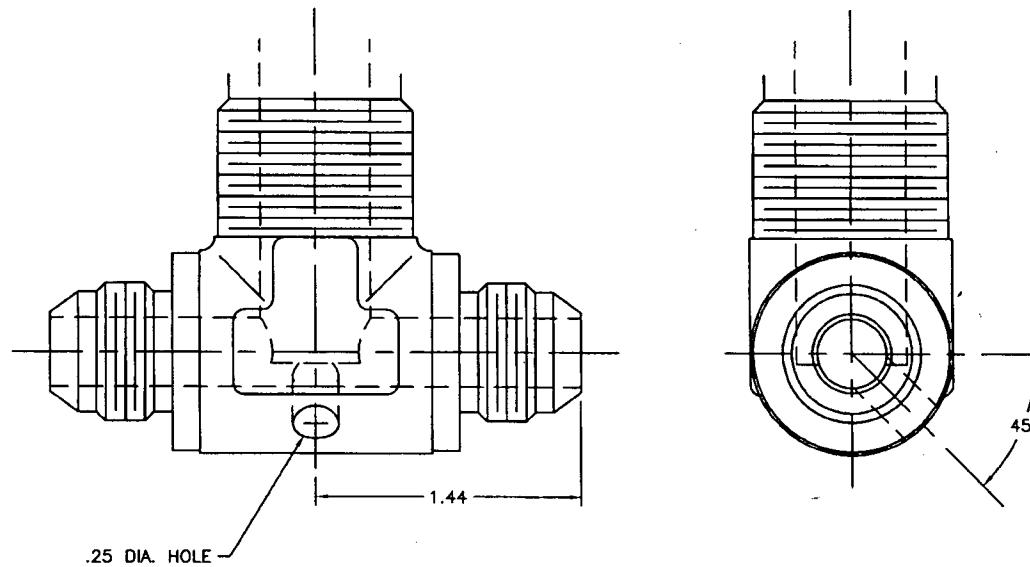
NOTES:

NO. REQ'D PER ASSY	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL.SPEC	ZONE	LIST OF MATERIAL		
							DRAFTSMAN	CHECK	TITLE
	-005	UNION		MAKE FROM AN815-4J UNION					
	-003	REDUCER TEE		MAKE FROM BELL P/N AS1035J080812 or 110-080-12C					
	-001	REDUCER TEE ASSY							
-001									

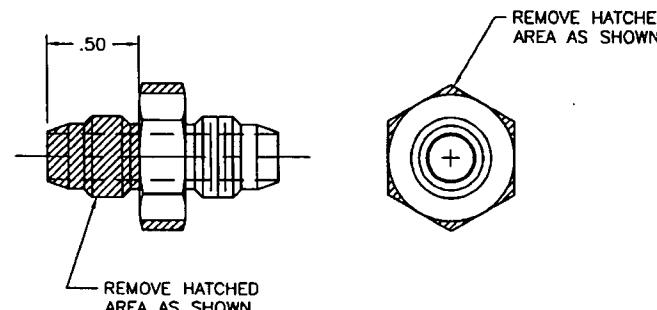
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DRAWN BY DRAFT NO.	REDO PER ASSY	NEXT ASSEMBLY	MOL	UNLESS OTHERWISE SPECIFIED $X \pm .1$ $XO \pm .03$ $XOC \pm .010$ ANGLES $\pm 1/2$	DRAFTER	D. NELSON	5/24/02	TITLE REDUCER TEE ASSY		
					CHECK	D. MURPHY	5/24/02			
					STRESS					
					PROL. ENGR.		DWG. SIZE	C	SCALE	2:1
					HEAT TREAT				DWG. NO.	41232-200-004
					FINISH	⚠	Era Aviation, Inc.		REV.	IR
									SHT 1 OF 2	



-003 REDUCER TEE



-005 FITTING

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 WITHOUT NOTICE  
 WORK ORDER  
 31779

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*Era Aviation, Inc.*

TRK	REDUCER TEE ASSY	REV
C	DRAW. NO. 41232-200-004 SHT 2 OF 2	IR

